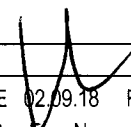
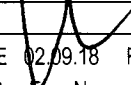


Date Thursday, 16/08/2007 10:22:54 AM  
User Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Jot Number	: 33992		
Estimate Number	: 10313		
P.C. Number	: N/A	Part Number	: D26483
This Issue	: 16/08/2007 S.O. No. : N/A	Drawing Number	: D2648 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 33059	Material	: N/A
Written By	: 	Due Date	: 05/09/2007 Qty: 200 Um: Each
Checked & Approved By	: 		
Comment	: Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev: Now on Waterjet 06-08-14 JLM		

## Additional Product

Jot Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010S16GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



Comment: Qty.: 0.0788 sf(s)/Unit Total: 15.7500 sf(s)  
1010/1025/A21/6aA SHEET  
(M1010S16GA)  
Batch: M10S 261 B07-08-19

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg D2648  
\*\*\*\*\*CUT WITH FILE D2648-1\*\*\*\*\*  
Dwg Rev: D B 07-08-19  
Prog Rev: D

200

2-Deburr if necessary

SAP

82/08/26

200

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 07-08-19

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/08/20

counter

4200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 10:22:54 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33992

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

SAD 07/08/26

counted

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SB 07/08/28

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R560Hardcoat

M105887/M105844 FC/2S 07/11/09

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD

07-11-12 (200)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD

07-11-12 (200)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642

FZ

07/11/12 (200)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. J. 07/11/12

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 17

M. J. 07/11/12

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/11/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 10:22:54 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33992

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(Signature)*  
D 07/11/13

Job Completion



*U 07-11-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

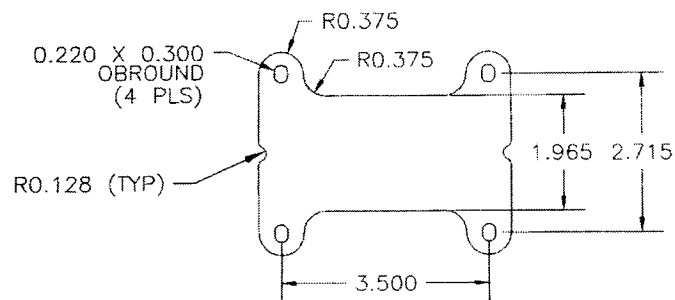
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

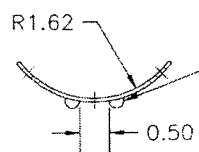
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# D2648-1 FLAT PATTERN

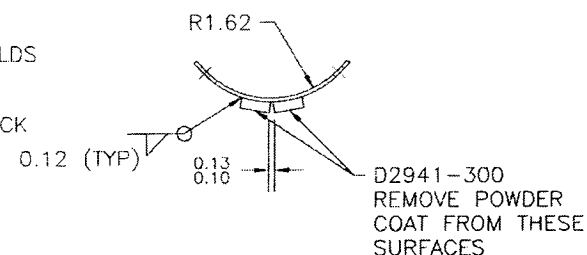


## SECTION A-A

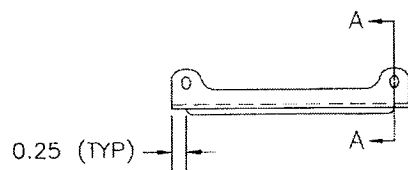


7560 HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.063 TO 0.125 THICK

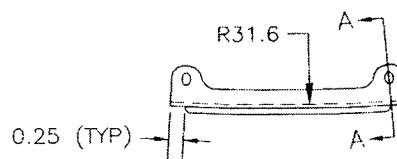
## SECTION B-B



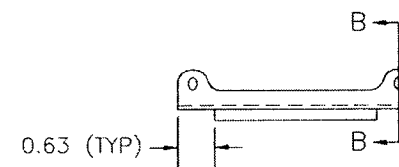
## D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED  
97.12.20 DS



BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLVILLE, TX
CHECKED	APPROVED	DRAWING NO. D2648
DATE	TITLE	SCALE
99.11.17	WEARPAD	1:2





## CUSTOMER RETURN

Initiator: Jan Kerr  
Company: Rotortech Services Inc.  
CRO TOLD  
Phone No: 561-684-6000

REFERENCE ONLY Date: March 18/08  
Invoice # 6092  
Order Entry # 5622

Reason for return: PADS NOT compatible with OEM tubes  
Attach Copy of DHS Return Authorization # 383

Receiving: 8/9/07 Freight Company: 1-PDLEP Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
10	D2648-3	33992	Wear pads		

Condition of packaging: \_\_\_\_\_ Photograph required: yes no

Paperwork attached: P/S \_\_\_\_\_ Invoice P ARC \_\_\_\_\_ Docs \_\_\_\_\_ Other \_\_\_\_\_

## QC:

Quarantine: \_\_\_\_\_ Location: \_\_\_\_\_ Condition of Part: good

Inspect: \_\_\_\_\_ Initial: P

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
10	D2648-3	33992	return to stock as per inv	<u>P</u>	38886	

## QA Coordinator:

Advise GM as to findings: \_\_\_\_\_ Initial: \_\_\_\_\_ Date: \_\_\_\_\_

Comments: \_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

Issue credit: yes no

GM Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Invoice Amount: \_\_\_\_\_  
Less Replacement: \_\_\_\_\_  
Restock Fee: \_\_\_\_\_  
Freight: \_\_\_\_\_  
Net Credit: \_\_\_\_\_  
DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: \_\_\_\_\_ Date: \_\_\_\_\_

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit